

Date: Friday, 23/05/2008 12:41:51 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 39463		
Estimate Number	: 10640		
P.O. Number	:	Part Number	: D34535
This Issue	: 23/05/2008 S.O. No. :	Drawing Number	: D3453 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35880	Material	:
Written By	:	Due Date	: 15/06/2008
Checked & Approved By	: <u>JLD 08.5.23</u>	Qty:	<u>15</u> Um: Each
Comment	: EST. REV. A 05.11.16 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1000	Inventory
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Comment: Qty.: 0.1733 f(s)/Unit Total : 1.0395 f(s)

AISI 304 SS round bar 1.000" dia.

(M304R0750)

Batch: 1105532 X13

~~100325 X 7~~

mmf 08/05/26

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA581 & DWG D3453,

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

mmf 08/05/26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

J.F. 08/06/22 (15)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLEVIS

Job Number: 39463

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F- 08/06/02

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F- 08-06-05

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W 2

PD 08-06-06 (15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09 JF

Job Completion



MF 08-06-06
CZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

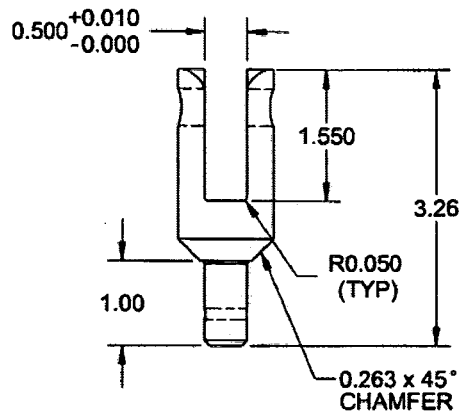
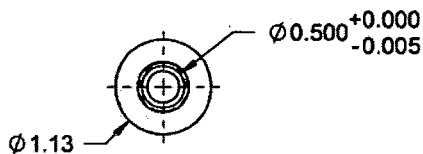
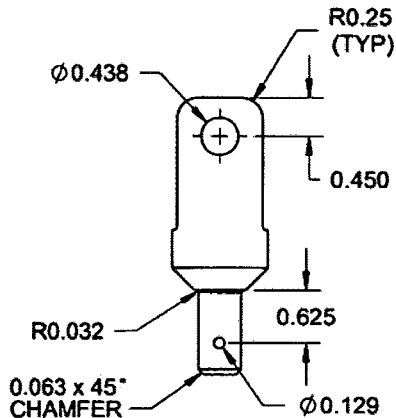
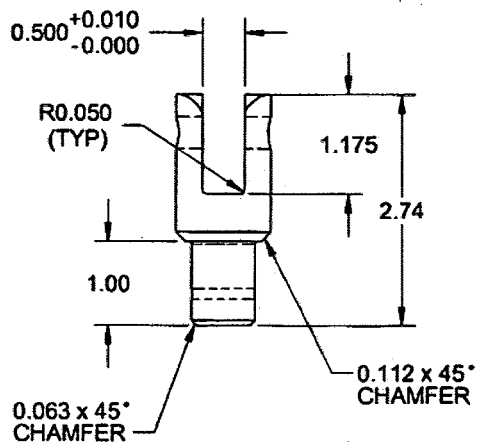
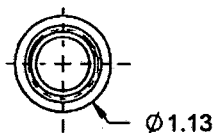
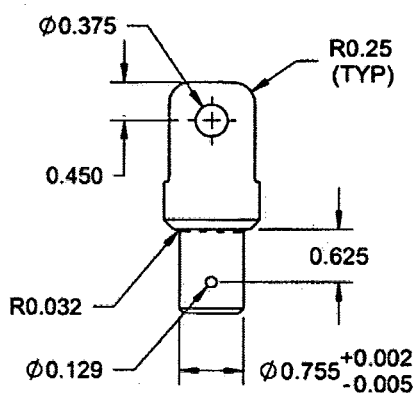

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 12
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO. 39463

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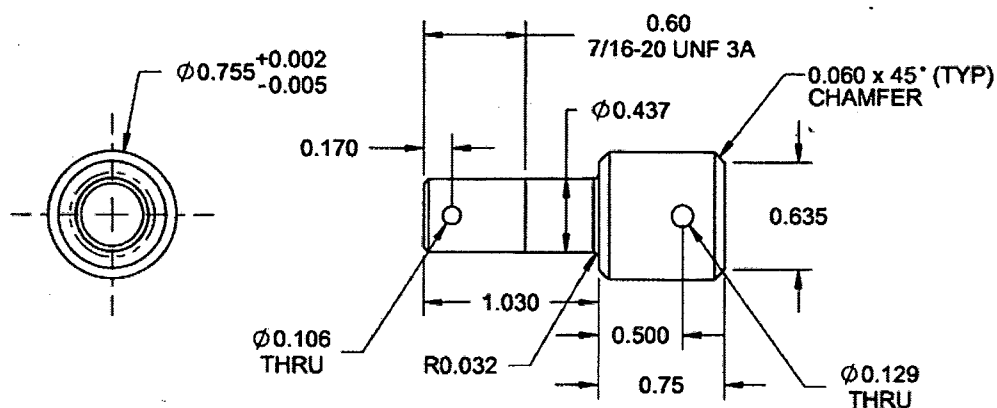
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 [Signature]

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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